AMENDMENTS TO THE SPECIFICATION

Please replace Paragraph **[0004]** with the following:

[0004] Basically, radial paths travel from root or base to tenon or blade tip until the front or back of the blade is cut to depth. The path then moves along the leading or trailing edge to cut to the desired depth, and continues to the uncut front or back of the blade to finish removing material in the same manner as the opposite. This process has traditionally been accomplished with what is called a "Hydrotel" machine, which uses a dovetail-shaped cutter with round inserts. These multi-spindle machines are quickly becoming antiquated, spending on maintenance and refurbishing is drastically reduced, and the owners are opting for new CNC machines. Lately, machinists have found that the radial cutting path is more cost effective, and the ability to reduce or eliminate secondary finishing operations is obtainable with creative programming and tooling. This includes, but is not limited to, the tilting of the milling machine's spindle, or the workpiece such that a ball-nosed tool will not cut with the surfaces of the tool ~~with~~that have minimal effective speeds and feeds.

Please replace Paragraph **[0022]** with the following:

[0022] The cutting insert 10 is also defined by first and second radiused edge surfaces 34, 36 that extend between the shorter sides of the face surfaces 12, 14. For purposes of convenience, the first and second edge surfaces 34, 36 will be referred to as shorter radiused edge surfaces 34, 36. A first cutting edge 38 is defined along the intersection of the long edge surface 22 with the upper face surface 12 and along the intersection of the long edge surface 22 with the shorter radiused edge surface 34. A second cutting edge 40 is defined along the intersection of the long edge surface 22 with the ~~upper~~lower face surface 14 and along the intersection of the long edge surface 22 with the shorter radiused edge surface 36. Because the insert 10 is symmetric about the longitudinal axis, L, a third cutting edge 42 is defined along the intersection of the long edge surface 24 with the upper face surface 12 and along the intersection of the long edge surface ~~22~~24 with the shorter radiused edge surface 34. A fourth cutting edge 44 (shown in phantom in FIG. 1) is defined along the intersection of the long edge surface 24 with the ~~upper~~lower face surface 14 and along the intersection of the long edge surface 24 with the shorter radiused edge surface 36. When one cutting edge becomes worn, the insert 10 may be indexed 180° about the axis, A, of the clamping screw

bore 16 to bring the other cutting edge on the same face surface 12, 14 into active cutting position. In addition, the insert 10 can be indexed 180° about a vertical axis, V, to bring the other cutting edge on the other face surface 12, 14 into active cutting position. The insert 10 may include a locating dimple 39 for assisting in the positioning of the insert 10 in the cutting tool.

Please replace Paragraph **[0027]** as follows:

[0027] In operation, a portion of the cutting edges 38a, 38b, 40a, 40b that are defined by the intersection of the ~~short~~cutting edge surfaces 38, 40 and the upper and lower surfaces 12, 14, respectively, provide for a full radiused cutting edge which is relatively large at the cutting edge itself. By virtue of the full radiused cutting edge, the insert 10 with the two radiused ends may effectively span the gap between two spaced inserts of an adjacent row. The strength of the cutting edges 38a, 38b, 40a, 40b (and 42a, 42b, 44a, 44b) are increased by forming the radiused corners on these cutting edges.